

Work Order ID 61697

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Page 1

Item ID: D412-769-011

Accept



Setup Start



Revision ID:

Item Name: Aft Facing Seats (LH/RH)

Stop



Start Date: 8/31/10 Start Qty: 1.00



Required Date: 9/03/10 Req'd Qty: 1.00



Reference: RA110074 - RETU RAN

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
IIN D412-769	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-769-011 CHG 001

Cust Item ID: DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D412-769-011	CHG	CHG001
DESC.	Aft Facing Seat, LH/RH	STC	SH08-38
LOT	B42932	STC	
MODEL	Bell 205/212/412	STC	

MADE IN CANADA

D2729-1

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Start Date: 8/31/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/03/10 Req'd Qty: 1.00



Customer:

Reference: RA110074

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

101



QC

Quality Control

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

Memo

INSPECT RA110074
D412-769-041 TO CONSIST OF
D412-769-041 B42986 CONSISTS OF:

Lable → 1 X D412-724-041 B44407 CHG001
ADD 4 X AN52510R6 TO KIT 50
Sul 08/31 B M113524

Lable → 1 X D412-724-043 B44408 CHG001
ADD 4 X AN52510R6 TO KIT
B M113524

1 X D412-769-043 B43041 -LH SEAT ASS'Y
D412-769-042 B42990 CONSISTS OF: S

Lable → 1 X D412-724-041 B44407 CHG001
ADD 4 X AN52510R6 TO KIT
B M113524 S

Lable → 1 X D412-724-044 B44409 CHG001
ADD 4 X AN52510R6 TO KIT B M113524 S
1 X D412-769-044 B43046 RH SEAT ASS'Y

ENSURE ALL IS COMPLETE
RETURN ITEMS INTO NEW B/N OF D412-769-011

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Item ID: D412-769-011

Accept



Setup

Start

**Revision ID:****Item Name:** Aft Facing Seats (LH/RH)

Stop

**Start Date:** 8/31/10 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 9/03/10 **Req'd Qty:** 1.00**Customer:****Reference:** RA110074**Approvals:** Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

105



Packaging

Packaging

**Operation
Description**

Pick Kit

**Set Up/
Run Hours**

0.00

Tool ID

10/8/13

Tool #

5

**Plan
Code**

S

**Accept
Qty**

5

**Reject
Qty**

0

**Reject
Number**

1005-87

**Insp.
Stamp**

110



QC

Quality Control

MemoPICK AS ABOVE
4 X AN52510R6 FOR EACHD412-724-041(X2)
D412-724-043
D412-724-044

0.00

120



Packaging

Packaging

Packaging

116

0.00

Rec

Memo
RE-PACKAGE USING NEW B/N

0.00

10/9/13P

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Item ID: D412-769-011

Accept



Setup Start



Revision ID:

Item Name: Aft Facing Seats (LH/RH)

Stop



Start Date: 8/31/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/03/10 Req'd Qty: 1.00



Customer:

Reference: RA110074

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/09/02 JF

JMF
(0-9-2)

Picklist Print

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Work Order ID: 61697



Parent Item: D412-769-011



Parent Item Name: Aft Facing Seats (LH/RH)

Start Date: 8/31/10

Required Date: 9/03/10

Comments: IPP rev A 08-07-17 new issue DD verified by:EC
10.03.23 as per IIN revC DD verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Purchased	Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN525-10R6				No			Each	188.0000	16.0000		(0/0/1158)	

Screw

Warehouse

Location

Main Warehouse

ST325

188

113524

188

Each 0.0000 1.0000

(0)

D412-769-011

Manufactured

No

Aft Facing Seats (LH/RH)

ORIGINAL B/N 42932

RA110074

B42932
RA110074

8/10/08/31

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH